

Work Order ID 69725

Wednesday, May 18, 2011 9:04:46 AM



Page 1

Item ID: D4016-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Half, Lid

Start Date: 5/18/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

11-05-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D4016	A								

100	Cut blanks as per folio	0.00							
Bandsaw	Memo	0.00	B.A.	11/06/09		6	0		
Jeaspa Bandsaw	CUT BLANK as per folio								

110		0.00							
HAAS 1	Memo	0.00	B.A.	11/06/09		6	0		
HAAS CNC vertical machine #1	MACHINE AS PER FOLIO FA874 AND DWG FOLIO REV: AA DWG REV: A								
	DEBURR								

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

B.A 11/06/09

6

φ

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

R.R 11.5.10

QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: PAT D

0.00

Packaging

Memo

0.00

Packaging

P.C 4/4/13 C

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Page 3

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00




QC

Memo

0.00

Quality Control

11/06/13 
CZ11/06/13

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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 18, 2011 9:04:52 AM

Page 1

Work Order ID: 69725

Parent Item: D4016-3

Parent Item Name: Hinge Half, Lid



Start Date: 5/18/2011

Required Date: 5/24/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: I[PP REV:A NEW ISSUE 09-11-27 JL VERIFIED BY:DD IPP Rev:B as
per dwg REV.A DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.000X1.000		Purchased	No			100	f	11.7440	0.08	0.505263			

304 bar 1.00 x 1.00

Location

Loc Qty

Loc Code

MAT050

11.744

113290

1.047

✓ 117130

10.697

0.5052 ft H.A 11/06/09

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	69725
Description: Hinge Half, Lid		Part Number:	D4016-3
Inspection Dwg: D4016 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.88	+/-0.030	0.876	✓		Vern	GA-01
0.13	+/-0.030	0.127	✓		"	"
0.250	+/-0.010	0.252	✓		"	"
R0.03	+/-0.030	R0.032	✓		R-G	ref.
0.13	+/-0.030	0.125	✓		Vern	GA-01
0.50	+/-0.030	0.500	✓		"	"
0.63	+/-0.030	0.626	✓		"	"
0.563	+/-0.010	0.562	✓		"	"
Ø0.257	+0.006/-0.001	Ø0.259	✓		"	"

Measured by: A.A	Audited by: R	Preliminary Approval:
Date: 11/06/09	Date: 11.6.09	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	AA

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

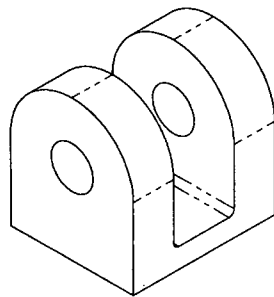
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

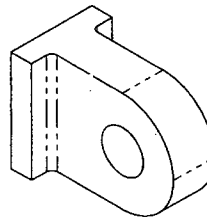
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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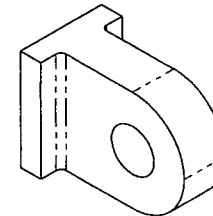
SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 49725
2/11/05-18



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID



D4016-5 HINGE HALF, LIGHT LID

RELEASED
 2010-02-16
MD

A	NEW ISSUE	JPH	10.01.29
REV.		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4016	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET HINGE	NTS
DATE	10.01.29	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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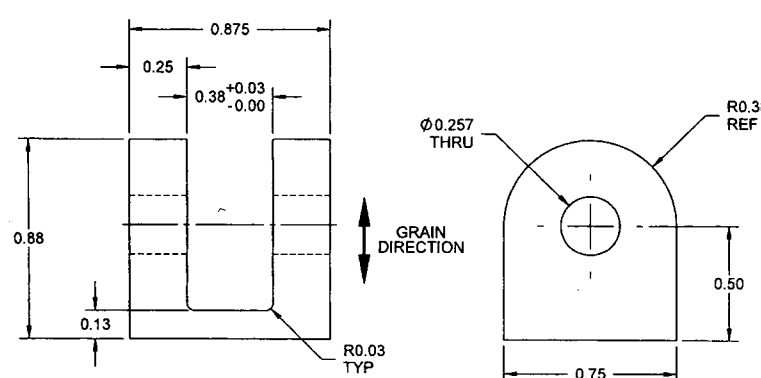
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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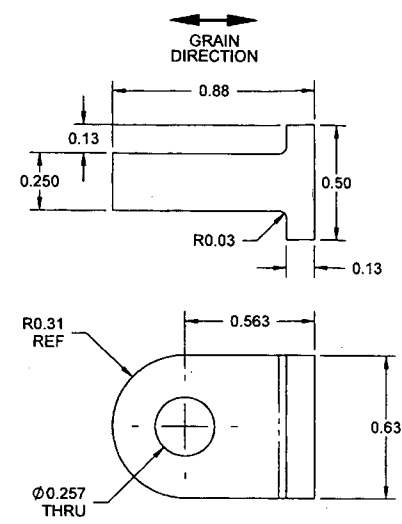
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u/069725



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

NOTES:

- 1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B
- 5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -1: 0.09 lbs
-3: 0.04 lbs
-5: 0.01 lbs

RELEASED
2010-02-16

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4016	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET HINGE	NTS
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